

5/46

DART AEROSPACE LTD	Work Order:	24723
Description: Doubler	Part Number:	D3144-13
05.11.02 C GJH Dwg: D3144 Rev. B page 41 04/12/01 RFF	Qty:	10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler		05.11.02	10
2	PG	Issue P/O: <u>200889</u> Email or Ship DXF file to vendor Laser Cut D3144-13 flat pattern per Dwg D3144 Possible Supplier: GFI or Industrial Laser Material release note is required		AP 05/11/02	10
3	RG	Receive and Inspect for transit damage Ensure material release note is attached		05/11/02	10
4	QC6	Inspect dimensions as per Dwg D3144		05/12/02	10
5	GA	Deburr	SAB	05/12/02	10
6	FP	Chemical Conversion Coat per QSI 005 4.1	SAB	05/12/02	10
7	FP	Powder Coat Black Sandtex (Ref: 4.3.5.7) per QSI 005 4.3	A.m06-04-03		10
8	QC3	Inspect Powder Coat	M 06-04-03		10
9	ST	Identify and Stock Loc. SA --	06/04/03		10
10	AC	Cost / part: _____	06/04/03		10
11	DC	Close W/O Inspect Level 21	06/04/06		10

Rev	Date	Change	Revised By	Approved
A	04.11.29	New issue	KJ/RF	<i>[Signature]</i>

RELEASED
R [04.11.30]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

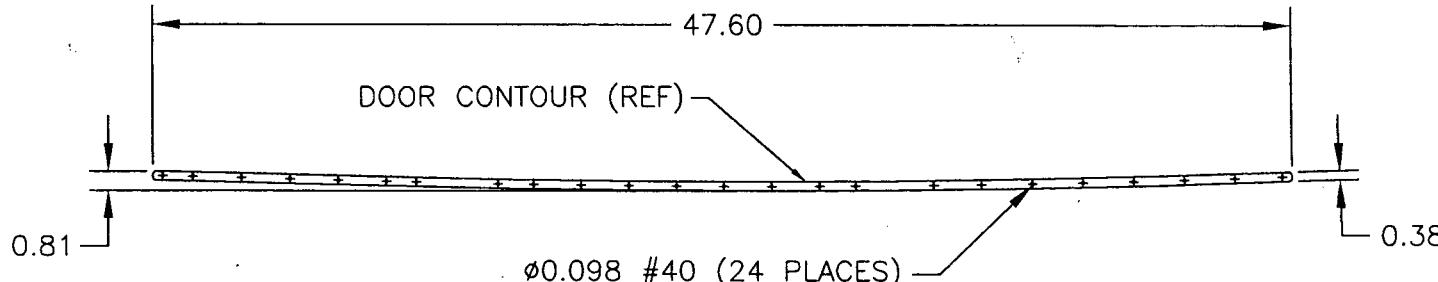
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/04/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		DATE	REV. C
05.10.19		TITLE	SHEET 4 OF 9

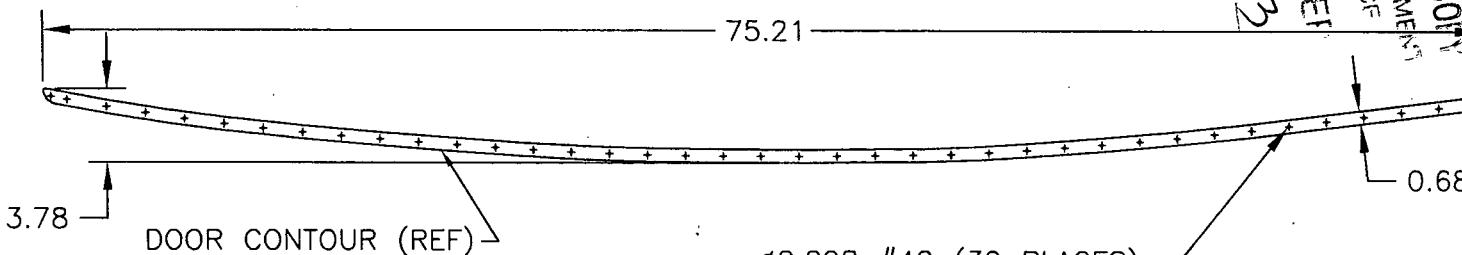


D3144-15 DOUBLER
SCALE 1:8

(C)

D3144-15 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-13 DOUBLER
SCALE 1:10

REPLACES PREMIER P/N B30-23000-211

D3144-13 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 02, 2005
03:54 pm

Work Order No	:	0024723	Department Code:
Project Name	:	D3144-13	Burden Flags : NNNNNNNN
Project For	:	WK546	WO Status : Open
Work Order Type	:	Main	Invoice State : Not Invoiced
Main WO Number	:		Invoice Date :
House Part Number	:	D3144-13	Invoice Number :
Description	:	Doubler	Invoice Amount : 0.00
Manufactured	:	Yes	
Amount Req'd	:	10	
Amount Done	:	0	Order Entry No :
Start Date	:	11-02-05	OE Value : 0.00
Est Finish Date	:	11-17-05	
Act Finish Date	:		Est Mark Up : 0.000%
Drawings Reqd	:	No	Actual Mark Up : 0.000%
Ok for Approval	:		
Approval Rec'd	:		\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

CERTIFICATE OF COMPLIANCE

CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE
POINTE CLAIRE, QC
H9R 1A1

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. **2** OUR JOB NO **J0135190** SHIPPING MEMO **0325138**

ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
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--	10 PCS	2008889	D3144-13		DOUBLER	C
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MATERIAL	SUPPLIED BY	MAT. REL. NO.
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AL 2024-T3 (QQ-A-250/4)	SAMUEL / KASIER ALUMINUM ATT'D	H/N 318740A8
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	PROCESS	PROCESSOR	RELEASE NOTE #
1			
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **22 NOVEMBER 2005**

G.F.I. Q.C. REP.

607-05



Programme d'Assurance Qualité Enregistré / Registered Q.A. Program
ISO 9001:2000 AS9100

LETTRE DE CONFORMITÉ -LETTER OF COMPLIANCE

Date: 18 NOVEMBRE 2005

Company Name: G.F.I. Division of Thomas & Betts limited
Address: 180 avenue Labrosse
City: Pointe Claire, Qué.
Zip Code: H9R 1A1

du client: 59583 **# de commande SSMQ:** 848091
Customer's order #: SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
2	1	.020" X 48" X 144"	2024 T3	AMS-QQ-A-250/4	318740A8

Bien à vous,
Yours truly,

Nicole Griffiths

Commis à l'administration.
Administration Clerk.



SHIP TO:
SAMUEL
SHIP TO
2360 DIXIE ROAD
MISSISSAUGA, ON, CA

SOLD TO:
SAMUEL
2225 FRANCIS HUGHES
LAVAL, PQ, CA H7S1N5

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4020327

CUSTOMER PO NUMBER:		CUSTOMER PART NUMBER:		SHIPPING/RUN #/LOAD ID:	GOVT CONTRACT NUMBER:	
N16484				100154/1		
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:	
1011719	3	8-OCT-2004	2024	BARE	T3	
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:	GAUZE:	WIDTH:	LENGTH:	
7050 LB	2 PCS EST.	202829	0.0200 IN	48.000 IN	0.000 IN	

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev04

Test Code: 1504

Test Results

Lot: 318740AB Cast 198

Drop 34

Ingot 4

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	65.1 : 66.0 (449 : 461)	44.1 : 45.3 (304 : 312)	16.6 : 17.8

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	
Actual	0.10	0.29	4.47	0.57	1.34	0.02	0.08	0.02	0.01	0.00	TOT	0.03

ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM & CHEMICAL CORPORATION (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772 (MIL-H-8088). ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR